

Date: Tuesday, 15/07/2008 4:19:58 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 40532 *2*
Estimate Number : 12709
P.O. Number :
This Issue : 15/07/2008 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : LARGE FAB ASSY
Previous Run : 39375
Drawing Name : GUIDE ASSEMBLY
Part Number : D3572041
Drawing Number : D3572 REV.C
Project Number : N/A
Drawing Revision : C
Material :
Due Date : 05/08/2008 Qty: *2* 10 Um: Each
Written By :
Checked & Approved By : *JLM 08.7.16*
Comment : Est Rev:A New Issue 07-02-07 JLM
est rev B revB dwg EC
Est Rev:C Removed D3572-7 Cap 07-06-11 JLM
Est Rev:D 08-05-27 Review process of Est. DD verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D35723	Guide
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s) GUIDE Batch: <i>B40562</i> <i>EL 8-10-21 X12</i>	
3.0	D35725	Bracket
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) BRACKET Batch: <i>B32415</i> <i>EL 8-10-21 X3</i>	
4.0	M6061T6T1000W188	6061T6 TUBE 1.00 X .188W
	Comment: Qty.: 2.3405 f(s)/Unit Total : 23.4045 f(s) 6061-T6 Round Tube 1.00"x 0.188 wall Batch: <i>B104480</i> <i>EL 8-10-21</i>	

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Sup today 22/10/08
Process Sheet

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Part Number: D3572041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

x2
EL 8-10-21

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8-08/10/21 (x2)

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572
A/R AL ROD Batch: *m104855*

x2
EL 8-10-21

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8-08/10/22 (x2)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08-10-21 BE

(x2)

10.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- grind weld flush at the end of tube only

EL 8-10-22

11.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

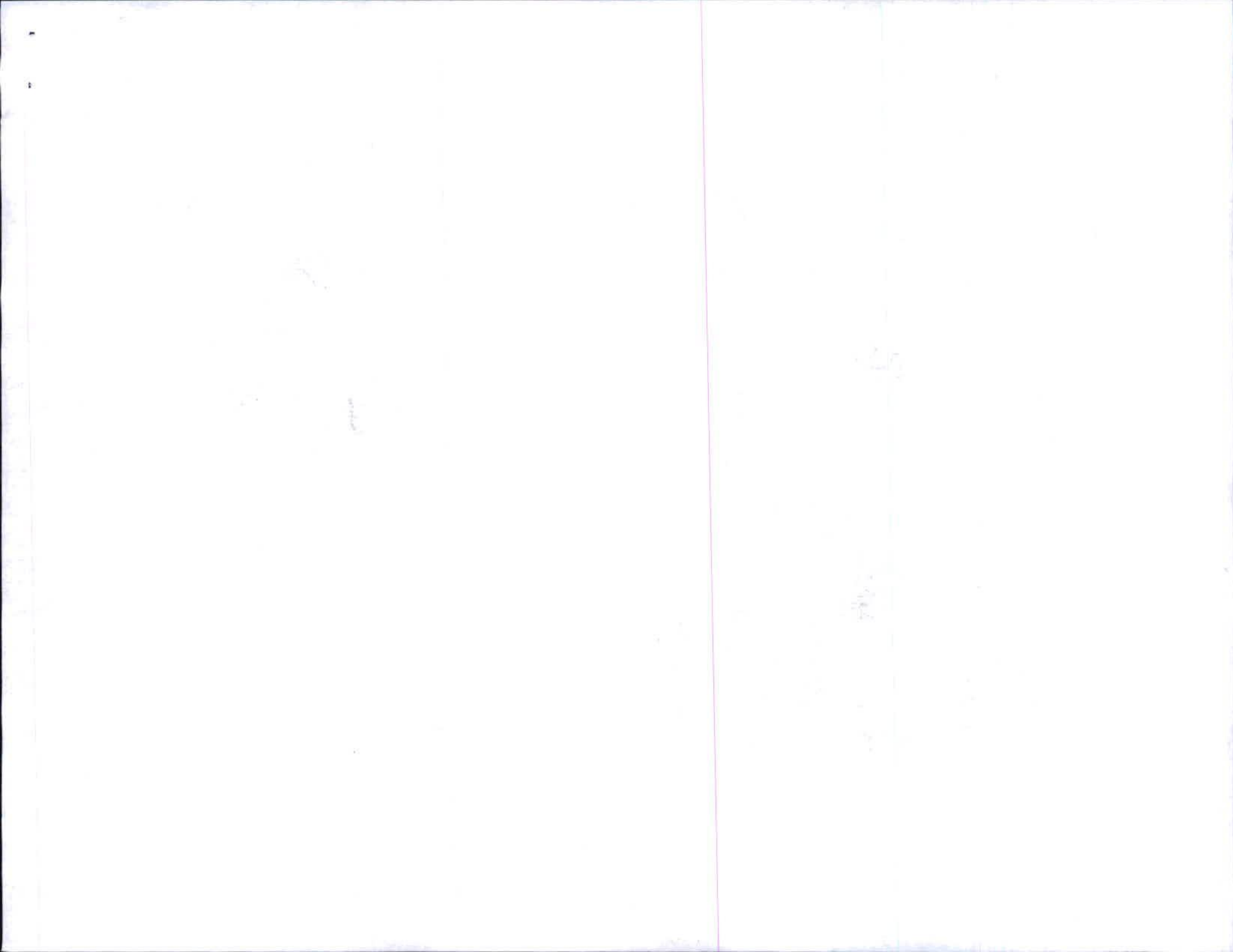
8-08/10/22 (x2)

12.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

8-08-10-22 (x2)



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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:20

OVEN TEMPERATURE:

320°

FINISH TIME:

10:50

m 106442

(2)

br 08-11-22

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-22

(x2)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

100 42751

18 08/10/22

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/22

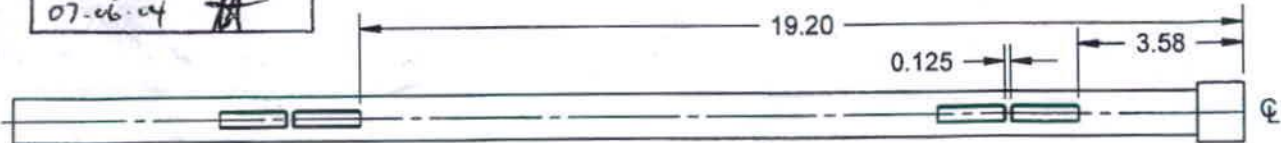
Job Completion



u 08.10.22

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 1 OF 2
DATE 07.06.01	TITLE GUIDE ASSEMBLY		SCALE 1:4
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

RELEASED07-06-01 *H*D3572-3 GUIDE
(4 PLACES)

3/16

4X

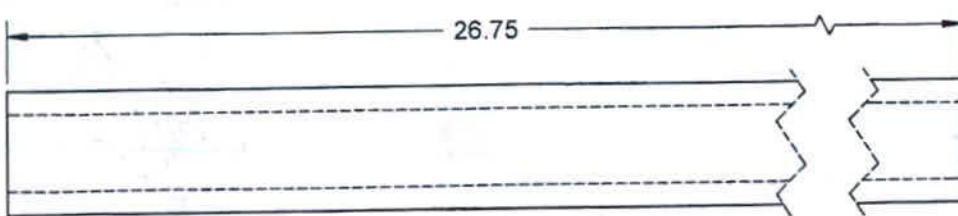
D3572-1 TUBE

D3572-041 GUIDE ASSEMBLY

D3572-5 BRACKET

D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE**

0.188 (REF)

Ø 1.000 (REF)

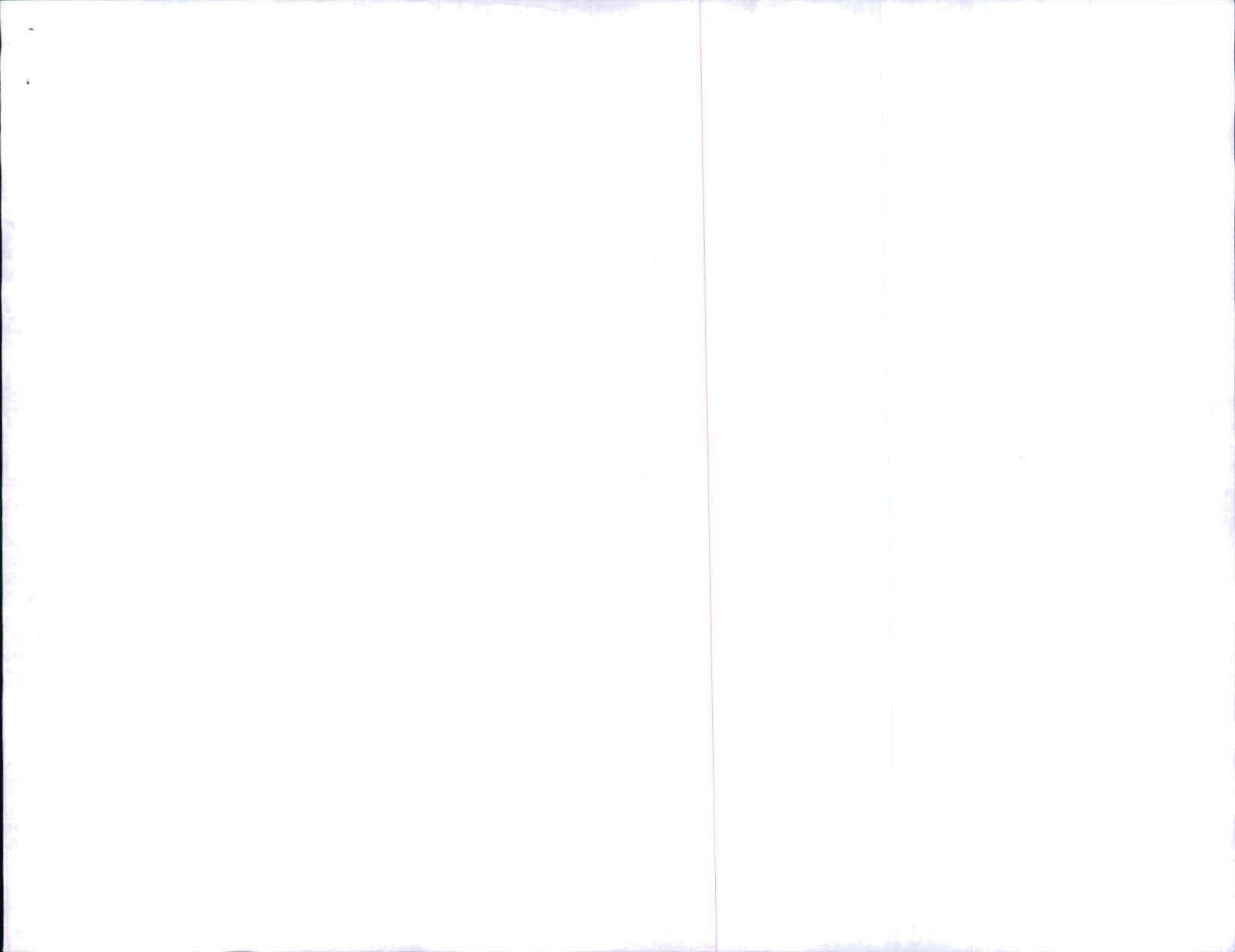
D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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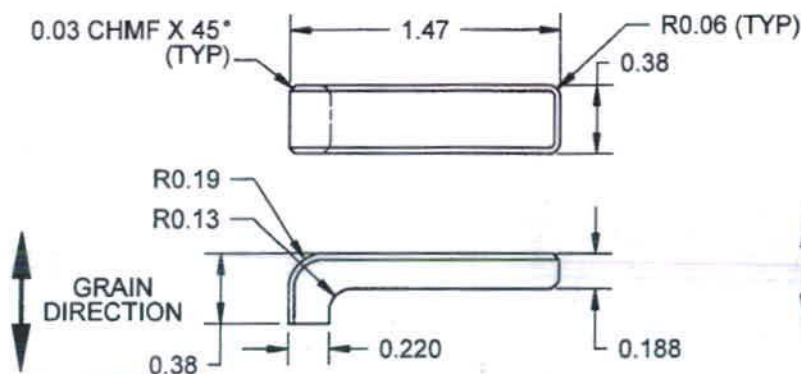
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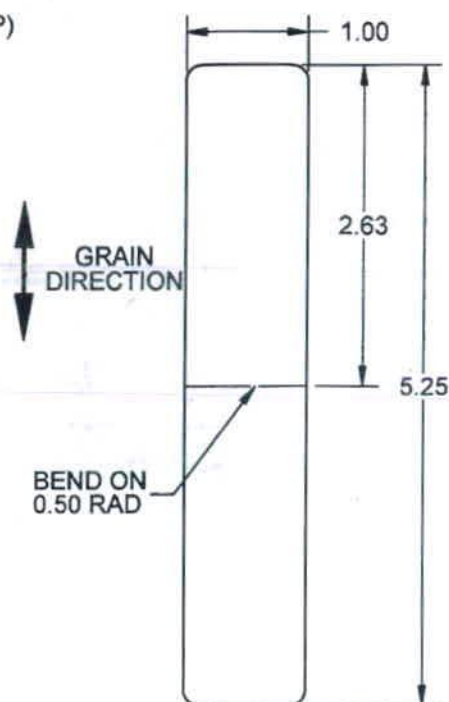




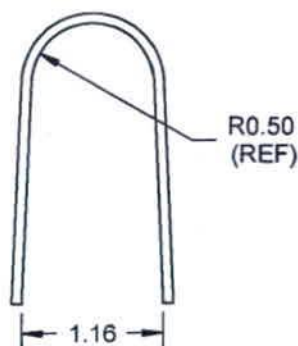
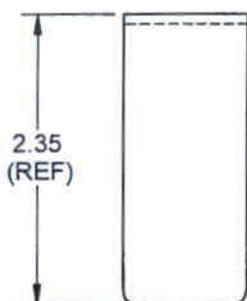
DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 2:3



1 **D3572-3 GUIDE**



2 **D3572-5F FLAT PATTERN**



**D3572-5 BRACKET
(MAKE FROM D3572-5F)**

RELEASED

07.06.01 *H*

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WORK ORDER
NO. 40532

D3572-3/-5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11
OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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